

Work Order ID 51936

Wednesday, September 09, 2009 3:18:19 PM

Page 1

Item ID: D206-667-203

Revision ID: C

Item Name: Crosstube Aft

Start Date: 9/11/2009 Start Qty: 1.00

Required Date: 9/30/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: *PL mr* Date: *09/10/09* Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Cust Item ID:

Customer:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D206-667-243	Rev C
--------------	-------

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D206-667-203 CHG003

Handwritten: BG 09/11/13

110

0.00



CNC Bend 2

BENDING MACHINE - CROSSTUBES

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT

Handwritten: 2X 26 09-11-02

120

0.00



QC

QC15- Crosstube Dimensional Check

Memo

0.00

Quality Control

Handwritten: 27 09/11/12

Handwritten: 24

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Page 2

Item ID: D206-667-203

Accept

Setup Start

Revision ID: C

Stop

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes. 2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243 Check dimensions between holes on all

DP 9-11-2

140

0.00



Crosstubes Chemical Conversion

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

1 - 140m 9-11-3

150

0.00



QC3- Inspect Part Finish

QC

Memo

0.00

Quality Control

2) 8 or 10

40

4

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Page 3

Item ID: D206-667-203

Accept



Setup Start



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Cust Item ID:

Required Date: 9/30/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

⇒ Soruloy



QC

Memo

0.00

Quality Control

170

Outsource process - NDT per QSI038 4.1

0.00



Outsource2

Memo

0.00

Outsource process - NDT

Liquid Penetrant Inspection as per QSI 038 Or ☐ Issue P/O: 10740 ☐ LPI as per ASTM 1417 ☐ Level 2 Attach copy of NDT results to work order

CY

1092115

180

Packaging

0.00



Packaging

Memo

0.00

Packaging

Ensure copy of NDT results attached to work order.

1092115

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	Ensure results are as per Dwg D206-667-243								
200		0.00							
	SprayPaint								
SprayPaint	Memo	0.00							
Spray Painting	1-Prime inside and outside crosstube as per QSI 005 4.2 □ 2-Paint outside crosstube with White Imron as per QSI 005 4.2 □ PRIME: □ Start								
	Time: <u>11:00</u> □ Finish Time: <u>12:00</u> □ PAINT: □ Start								
	Time: <u>3:00</u> □ Finish Time: <u>4:30</u>								
210	QC14- Inspect Spray Paint	0.00							
QC	Memo	0.00							
Quality Control	Wrap in plastic bag to protect from scratches								

MA 09 11 09 ①

ST 09 11 - 10

MA 09 11 11 ①

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Item ID: D206-667-203

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Aft

Start Date: 9/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/30/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/11/13 7052

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

MO 09/11/13

✓

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-667-203

Location: _____ □ PPP Rev: ①

9/11/13 7052

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Item ID: D206-667-203

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Aft

Start Date: 9/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/30/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/17 *[Signature]*
mf
09-11-16

Picklist Print

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Page 1

Work Order ID: 51936

Parent Item: D206-667-203RevC

Parent Item Name: Crosstube Aft

Comments:

Start Date: 9/11/2009

Required Date: 9/30/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD516

Purchased

No

100

Each

1,202.000

18.0000



Washer

9/11/09 sl @

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1202

100564

2

106167

6

107534

34

107959

43

108246

46

108672

2

109059

49

109752

22

110363

46

110523

57

111279

43

112082

352

112314

500

18x50

D206-667-

203TRNRevC

Manufactured

No

220

Each

2.0000

1.0000



Crosstube Turning Detail

B-52743

MS 09-10-30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

2

45623

1

45625

1

Picklist Print

Page 2

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Work Order ID: 51936



Parent Item: D206-667-203RevC



Parent Item Name: Crosstube Aft

Start Date: 9/11/2009

Required Date: 9/30/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2873-043RevA Manufactured No

220 Each 53.0000 2.0000



Nut Plate Assembly

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST 53

45370 18

45422 15

50002 20

mt 09/11/09

D2873-045RevA Manufactured No

220 Each 71.0000 2.0000



Nut Plate Assembly

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST 71

45210 11

46772 20

50001 40

mt 09/11/09

Picklist Print

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Work Order ID: 51936



Parent Item: D206-667-203RevC



Parent Item Name: Crosstube Aft


Start Date: 9/11/2009

Required Date: 9/30/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2892-1RevA		Manufactured	No			230	Each	48.0000	2.0000			
												
Support												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	48	
35581	4	
<u>41986</u>	20	
42785	20	
45936	4	

ml 09 11 11

D3595-063-450RevA

Manufactured

No

230

Each

81.1789

4.0000



RUBBER CUSHION

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	74	
<u>50953</u>	74	
Main Warehouse		
ST	7.1789	
38959	2	
43210	4.8	
46465	0.3789	

ml 09 11 11

Picklist Print

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Work Order ID: 51936



Parent Item: D206-667-203RevC



Parent Item Name: Crosstube Aft

Start Date: 9/11/2009

Required Date: 9/30/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20601-AD4W10		Purchased	No			230	Each	241.0000	14.0000			
RIVET												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

241

110665

100

111177

141

Purchased

No

260

Each

150.0000

10.0000



ml 09 11 12

9/11/13 RSP

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

150

107013

8

110363

2

111425

2

111819

38

112314

50

112385

50

M112805

2x SP
8x

AN5-10A



Bolt

Picklist Print

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Work Order ID: 51936



Parent Item: D206-667-203RevC



Parent Item Name: Crosstube Aft

Start Date: 9/11/2009

Required Date: 9/30/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN5-32A 7 Bolt		Purchased	No			260	Each	79.0000	4.0000		9/11/13	sl

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

79

106242

3

106519

4

110363

17

111916

5

112082

50

AN5-34A 1



Bolt

Purchased

No

260

Each

50.0000

4.0000



4x 50

9/11/13 sl

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

50

104679

2

105408

1

107013

2

111425

45

4x 50

Picklist Print

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Work Order ID: 51936

Parent Item: D206-667-203RevC

Parent Item Name: Crosstube Aft

Comments:

Start Date: 9/11/2009

Required Date: 9/30/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L5

Purchased

No

260

Each

1,331.000 4.0000



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1331

110382

10

111636

321

112314

1000

MS21920-22

Purchased

No

260

Each

114.0000 4.0000



Clamp(per MIL-DTL-8783C)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

114

109495

14

110260

50

111210

50

9/11/13 SP

4x SP

ml 09 11 11

Wednesday, September 09, 2009 3:18:26 PM

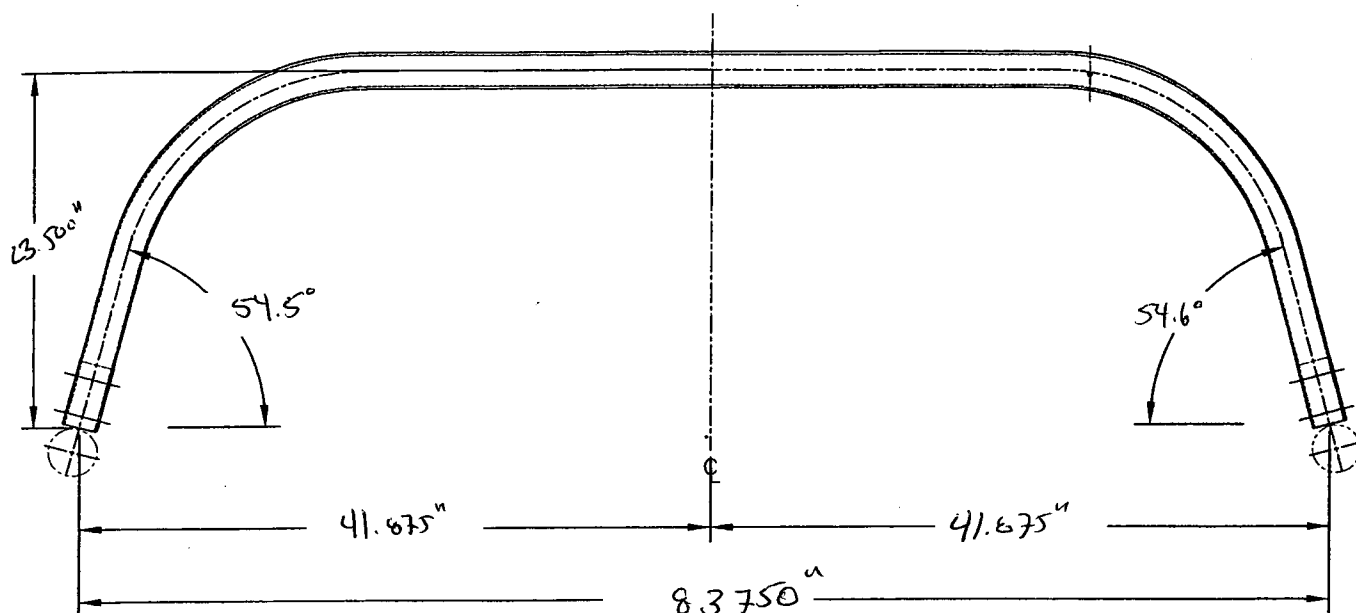
Shop Packet Print

Page 6

DART AEROSPACE LTD		Work Order:	51936
Description: Crosstube High Aft (206L)		Part Number:	D206-667-203
Inspection Dwg: D206-667-243	Rev: B C		Page 1 of 1

09.09.21

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments

QC15 Inspection	S
Date	07/11/02

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item	Qty -243	Part Number	Description
1	X	D206-667-243	CROSSTUBE ASSEMBLY (206L HIGH AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

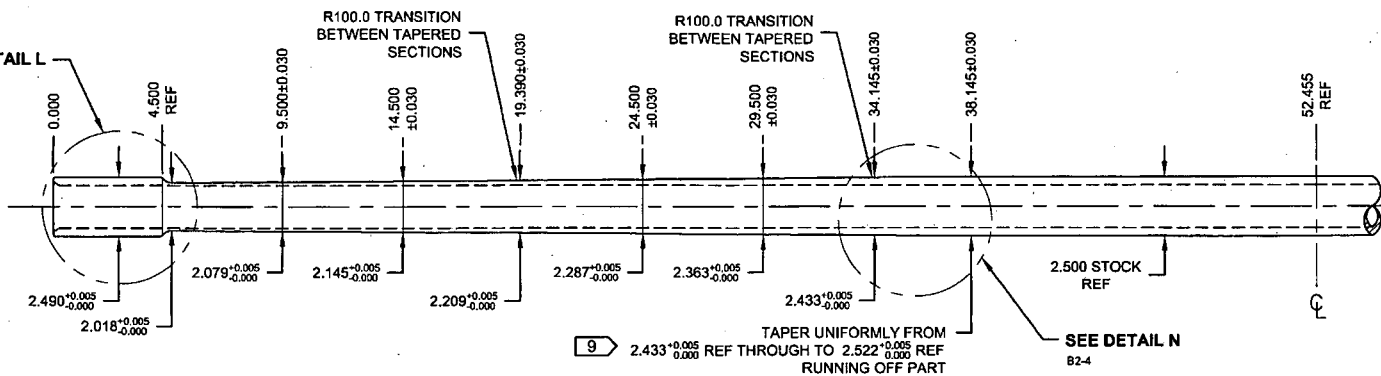
- 1) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-243" AND BATCH NUMBER ON
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 21.9 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER
QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE
D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE
LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51936

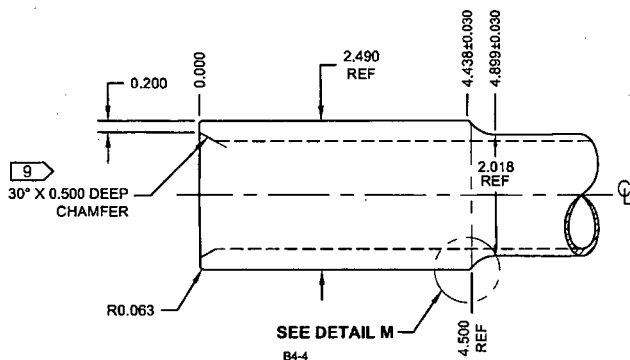
RELEASED
08/11/06

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-450 WAS D2856-400-773 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN 4-3, C5-3, D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D206-667-243	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

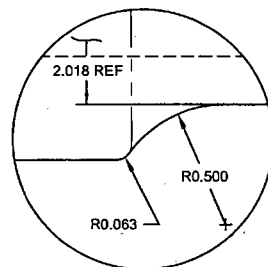
SEE DETAIL L
B7-4



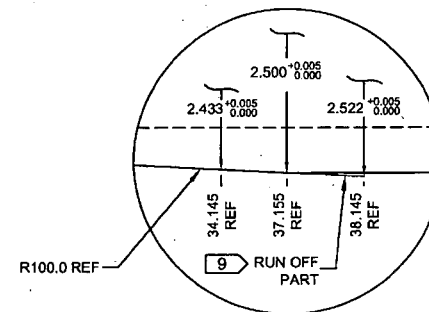
C TURNING DETAIL



DETAIL L: CROSSTUBE CUFF
NOT TO SCALE



DETAIL M: CUFF TRANSITION
NOT TO SCALE



DETAIL N: TAPER RUN-OFF
NOT TO SCALE

RELEASED
08/11/2006

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-243	SHEET 4 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSS-TUBE ASS'Y (206L HIGH AFT)	NTS
DE APPR.	RF	COPYRIGHT © 2000 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		

W/ 51936

P- 15307

ACUREN

LIQUID PENETRANT TEST REPORT

PAGE 1 OF 4

CLIENT: DATA ACQUISITION DATE: NOV 17 2009 TIME: AM PM

ATTENTION: ALLEN J. HANTEL ACUREN JOB NO.: 100-09-001633

ADDRESS: 1270 ABERDEEN ST POWO NO.: 10711

ANDRES BAYANI WORK LOCATION: PC HSP ANDRA INSIDE

K6H 3K7 ACCEPTANCE STD.: ASTM 1417 REV. DATE: 2007

PROJECT: F.P.T. ON CROSS TUBES

ITEM(S) EXAMINED: 10 UNITS

JOB DESCRIPTION: WET FLUORESCENT LIQUID PENETRANT INSPECTION

PROCEDURE NO.: LT002 REV. DATE: --- TECHNIQUE NO.: LT002 REV. DATE: ---

PART NO.: --- MATERIAL: ALUMINUM THICKNESS: ---

SCOPE: CARRIED OUT 100% EXTERNAL

TEST DETAILS

METHOD: ☒ FLUORESCENT ☐ VISIBLE ☐ WATER WASH ☐ SOLVENT REMOVAL ☐ POST EMULSIFIER

FAMILY BRAND: MAKRAFLEX BLACK LIGHT SN: 1059 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc

PENETRANT: 2L07 MINIMUM DWELL TIME: 45 MIN. LIGHTING EQUIP.: ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE

PENETRANT REMOVER: H00 MINIMUM DRY TIME: >10 MIN. OTHER: LASINO

DEVELOPER: SD 52 MINIMUM DWELL TIME: 10 MIN. LIGHT METER SN: --- CAL DUE DATE: DEC. 8, 09

DEVELOPER TYPE: ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE

SURFACE CONDITION: ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☐ CLEAN BARE METAL

SURFACE TEMPERATURE: ☐ < -4°C/20°F ☐ -4°C/20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (<input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL)		ACCEPT	REJECT
ITEM	COMMENTS		
1	CROSS TUBE, W.O. 51935	/	
1	CROSS TUBE, W.O. 51936	/	
1	CROSS TUBE, W.O. 53314	/	
1	CROSS TUBE, W.O. 53315	/	
1	CROSS TUBE, W.O. 52970	/	
1	CROSS TUBE, W.O. 52971	/	
1	CROSS TUBE, W.O. 52859	/	
1	CROSS TUBE, W.O. 52860	/	
1	CROSS TUBE, W.O. 52972	/	
1	CROSS TUBE, W.O. 52973	/	

Scope of Services: The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibility of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care: In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE: Jan Tiley DTR# E-85848

TECHNICIAN (SIGNATURE): [Signature] REPORT REVIEWED BY: [Signature]

NAME (Print): Johnston NAME: --- INITIALS: ---

CGSB Level: 2 SNT Level: 2 CGSB Level: --- SNT Level: ---

CGSB Reg. No: 6066 CGSB Reg. No: ---

WHITE - CLIENT COPY

CAMRY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

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